



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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JAN 13
CPC

D350-591-312
Job Sheet 201574



Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 1/10/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	1/10/20		0.00	10.00	Large Fab - 1		CC
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	10 pcs	1/10/20		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	10 pcs	1/10/20		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		



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Container No: S226994



Part: D350-591-312

Job No: 201574

Serial No/Batch: S226994

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 11, FAA STC SH967NE 04/12/21, BRAZIL 1

Plex 10/7/19 3:12 PM Dart.lajeunesse.marie

140 Handfinish - 1-1 Chemical-B4B	10 pcs	1/10/20	0.00 1.87	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	BE 8/9-10-29
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	10 pcs	1/10/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	OCT 30 2019 40
				QC 7 - 24	9-89
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	

				QC 7 - 79	
180 Large Fab - Steps - 2 - B4B	10 pcs	1/10/20	0.00 10.00	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	SLA
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
190 QC 10	10 pcs	1/10/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS 24 9-89
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
200 QC 5	10 pcs	1/10/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	DAS 24 9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
210 Handfinish - 1-2- Chemical- B4B	10 pcs	1/10/20	0.00 1.87	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	★ NOV 01 2019
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	

						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
220 Powdercoat - 1 White Gl(A)- B4B	10 pcs	1/10/20	0.00	2.98		Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BL 19-11-05
						Powdercoat - 4 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	10 pcs	1/10/20	0.00	1.87		Handfinish - 3 - 1 - B4B	
						Handfinish - 3 - 2 - B4B	3EB 19-11-04
						Handfinish - 3 - 3 - B4B	
						Handfinish - 3 - 4 - B4B	
240 QC 3	10 pcs	1/10/20	0.00	0.00		Handfinish - 3 - 5 - B4B	
						QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	68-6
						QC 3 - 68	NOV 21 2019 89
						QC 3 - 9	SD
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
250 Packaging 1-1 - Pick Kit - B4B	10 pcs	1/10/20	0.00	0.00		Packaging 1 - 1 - B4B	
						Packaging 1 - 2 - B4B	
						Packaging 1 - 3 - B4B	
						Packaging 1 - 4 - B4B	
						Packaging 1 - 5 - B4B	
						Packaging 1 - 6 - B4B	
						Packaging 1 - 7 - B4B	
						Packaging 1 - 8 - B4B	
						Packaging 1 - 9 - B4B	
						Packaging 1 - 10 - B4B	
						Packaging 1 - 11 - B4B	
						Packaging 1 - 12 - B4B	
						Packaging 1 - 13 - B4B	
						Packaging 1 - 14 - B4B	
						Packaging 1 - 15 - B4B	
						Packaging 1 - 16 - B4B	
						Packaging 1 - 17 - B4B	
						Packaging 1 - 18 - B4B	
						Packaging 1 - 19 - B4B	
						Packaging 1 - 20 - B4B	
						Packaging 1 - 21 - B4B	
						Packaging 1 - 22 - B4B	
						Packaging 1 - 23 - B4B	pc
						Packaging 1 - 24 - B4B	

						Packaging 1 - 25 - B4B	
						Packaging 1 - 26 - B4B	
						Packaging 1 - 27 - B4B	
						Packaging 1 - 28 - B4B	
						Packaging 1 - 29 - B4B	
						Packaging 1 - 30 - B4B	
						Packaging 1 - 31 - B4B	
						Packaging 1 - 32 - B4B	
						Packaging 1 - 33 - B4B	
						Packaging 1 - 34 - B4B	
						Packaging 1 - 35 - B4B	
						Packaging 1 - 36 - B4B	
260	QC 4	10 pcs	1/10/20	0.00	0.00	QC 4 - 28	
						QC 4 - 58	
						QC 4 - 69	
						QC 4 - 9	
						QC 4 - 46	
						QC 4 - 68	
						QC 4 - 72	
						QC 4 - 74	
						QC 4 - 75	MB 11/26/2019
						QC 4 - 78	
270	Packaging 3-1 - Stock - B4B	10 pcs	1/10/20	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	MB 11/26/2019
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	DAS
						Packaging 3 - 36 - B4B	21
275	DC - 1 - B4B	10	1/10/20	0.00	0.00	DC - 1 - B4B	DEC 04 2019

013117

	pcs			DC - 2 - B4B	
280 QC 21 - FG	10	1/10/20	0.00 0.00	QC 21 - FG - 21	DAS
	pcs			QC 21 - FG - 70	21
				QC 21 - FG - 53	21

DEC 04 2019

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod M138989 3-Grind End Plate flush B139019

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat

180 - Weld per dwg A/R Aluminum rod Batch: B139019 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss Ref: 4.3.5.1) per QSI005 4.3-Alum START TIME: 9:00 OVEN TEMPERATURE: 320°FINISH TIME: 9:30 M. 21186230 - Wing Walk as per dwg QSI005 4.4 Batch 5209362

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109 F6039

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	<u>5220700</u>
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	<u>5223692</u>
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	<u>5224905</u> ✓
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	<u>5223196</u> ✓
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	<u>5141237</u> ✓
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	<u>5225229</u>
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5228670</u>
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5227871</u>
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
D2230-3	Mounting Lug	40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
D2618	Bushing	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
D2856-400-720	Abrasion Strip 4" X 7.20"	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
D3235-1	Mounting Lug	20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
D3278-041	Support Assembly	10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	<u>5225231</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	19	0
	D3219-1	20	123	0
	D3272-1	10	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	21	0
	D3066-1	20	68	0
	MS20600-AD4W4	160	819	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	110	0
	AN4-13A	80	614	0
	AN5-36A	20	98	0
	D2230-3	40	201	0
	D2618	20	222	0
	D2856-400-720	20	98	0
	D3235-1	20	98	0
	D3278-041	10	2	0
	MS21042L3	20	3,147	0
	MS21042L4	80	1,489	0
	MS21042L5	20	320	0
	NAS1149D0363J	40	498	0
	NAS1149D0463J	160	2,429	0
	NAS1149D0563J	40	1,159	0

Part Specifications

Specifications could not be found.

Plex 10/7/19 3:12 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

[illegible]